

Work Order ID 137673

Wednesday, October 21, 2015 1:13:33 PM

137673

Page 1

Item ID: D3508-3 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Wearplate Fwd Center
 Start Date: 10/7/2015 Start Qty: 8.00 ***8*** Cust Item ID:
 Required Date: 10/7/2015 Req'd Qty: 8.00 ***8*** Customer:
 Reference:

Approvals: Process Plan: ML5 Date: OCT 21 2015 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3508	Rev C

100	FLOW WATER JET	0.00							
100									
Waterjet	Memo	0.02							
FLOW CNC Waterjet	1-Cut as per Dwg D3508 Dwg Rev: <u>C</u> Prog Rev: <u>C</u> 2- Deburr if necessary								

110	QC2- Inspect parts off machine FAI/FAIB	0.00							
110									
QC	Memo	0.00							
Quality Control									

120	QC8- Inspect parts - second check	0.00							
120									
QC	Memo	0.00							
Quality Control									

DAS
38
NOV 15 2015

Work Order ID 137673

Wednesday, October 21, 2015 1:13:33 PM

137673

Page 2

Item ID: D3508-3 Accept ***N900040100*** Setup Start ***NS1***
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 Start Date: 10/7/2015 Start Qty: 8.00 ***8*** Cust Item ID:
 Required Date: 10/7/2015 Req'd Qty: 8.00 ***8*** Customer:
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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	NC BRAKE	0.00				DAS 30 9-89	DAS 36 9-89		
130	Memo	0.00				8			NOV 04 2015
Brake NC	1-Form on brake using DT8326 and DT8261as per Dwg D35082-Form joggle as per Dwg D3508 Using DT8158								
Brake NC									
140	QC5- Inspect part completeness to step on W/O	0.00							
140	Memo	0.00							DAS 38 9-89 NOV 05 2015
QC									
Quality Control									
150	Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3	0.00							
150	Memo	0.00							
Powdercoat	START TIME: 1:45 OPEN TEMPERATURE:								
Powder Coating	FINISH TIME: 2:15								

Work Order ID 137673

Wednesday, October 21, 2015 1:13:33 PM

137673

Page 3

Item ID: D3508-3 Accept ***N900040100*** Setup Start ***NS1***
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Required Date: 10/7/2015 Req'd Qty: 8.00 ***8*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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160

QC3- Inspect Part Finish

0.00

160

QC

Memo

0.00

Quality Control

DAS
389-89
NOV 06 2015

170

Identify as per dwg & Stock Location: FP-002 0.00***170***

Packaging

Memo

0.00

Packaging

LOCATION : FP002

xs d 201 5/16/06

180

QC21- Final Inspection - Work Order Release 0.00

180

QC

Memo

0.01

Quality Control

NOV 06 2015

MCSSH
20151106

Picklist Print

Wednesday, October 21, 2015 1:13:36 PM

Page 1

Work Order ID: 137673

137673

Parent Item: D3508-3

D3508-3

Parent Item Name: Wearplate Fwd Center

Start Date: 10/7/2015

Required Date: 10/7/2015

Start Qty: 8.00

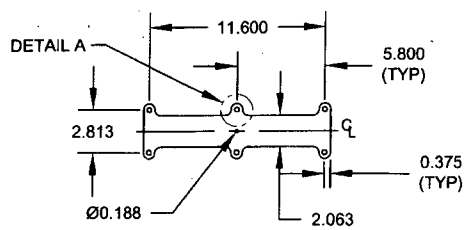
Required Qty: 8.00

Comments:

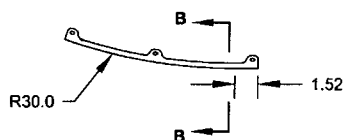
IPP Rev:A New Issue 06-06-20 JLM
IPP Rev:B Now SS as per Rev B 06-12-15 JLM
IPP Rev:C Rev C dwg 07-12-06 DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S20GA		Purchased	No			100	sf	119.9000	0.734	6.181053			
M304S20GA									**				
304/316 .040 Sheet													
						<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>					
						MAT020	119.9						
						m132387	119.9						
										<u>8.8</u>			

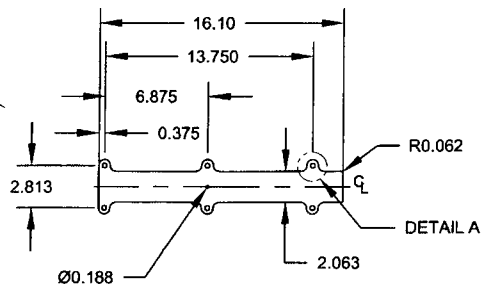
02/15/11/04



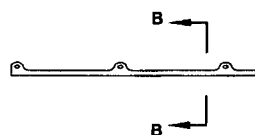
D3508-1 FLAT PATTERN



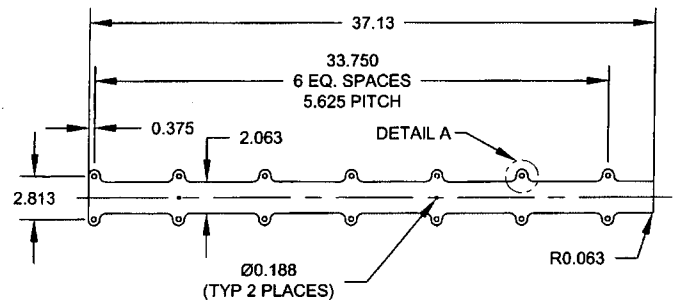
**D3508-1 BENDING DETAIL
(MAKE FROM D3508-1F)**



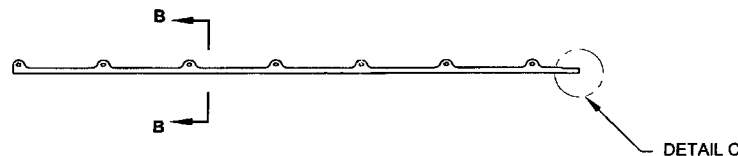
D3508-7F FLAT PATTERN



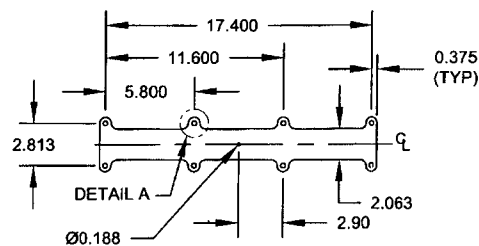
**D3508-7F BENDING DETAIL
(MAKE FROM D3508-7F)**



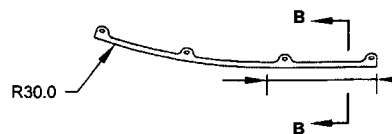
D3508-3 FLAT PATTERN



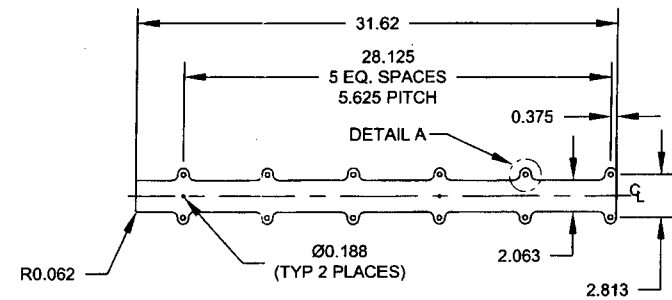
**D3508-3 BENDING DETAIL
(MAKE FROM D3508-3F)**



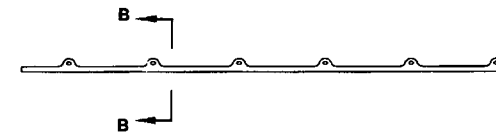
D3508-9F FLAT PATTERN



**D3508-9F BENDING DETAIL
(MAKE FROM D3508-9F)**



D3508-5 FLAT PATTERN



**D3508-5 BENDING DETAIL
(MAKE FROM D3508-5F)**

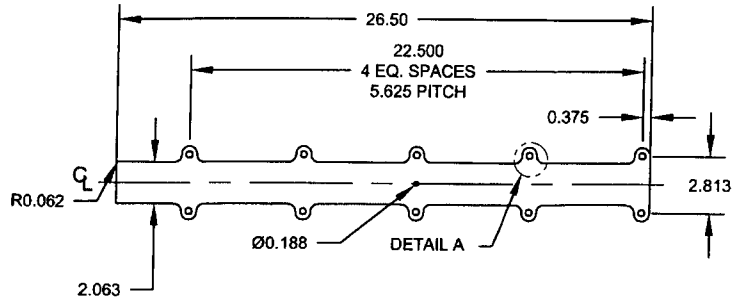
NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF. DART MATERIAL SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) WELD PER DART QSI 004
- 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: 0.005 TO 0.015
- 7) IDENTIFICATION: NONE
- 8) WEIGHT: D3508-1 - 0.47 lbs, D3508-3 - 0.95 lbs, D3508-5 - 0.77 lbs, D3508-7 - 0.39 lbs, D3508-9 - 0.45 lbs, D3508-11 - 0.64 lbs, D3508-13 - 0.25 lbs

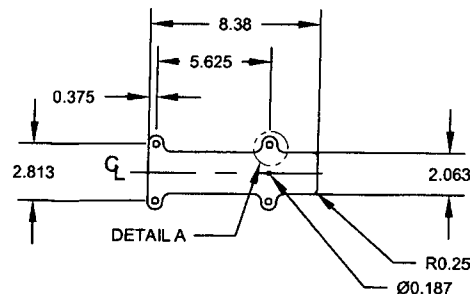
RELEASED
07.11.16

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RETURN TO
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UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 137673.MLS
15-10-08

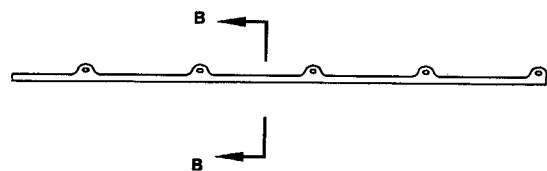
C	ADD -9/-11/-13 MOVE TAB OUTBOARD (2.813 WAS 2.733) CHANGE DRAWING FORMAT	PH	07.04.20
B	CHANGE STAINLESS STEEL, WIDEN	PH	06.10.27
A	NEW ISSUE	PH	06.04.21
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	07.04.20		
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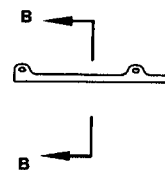
D3508-11F FLAT PATTERN



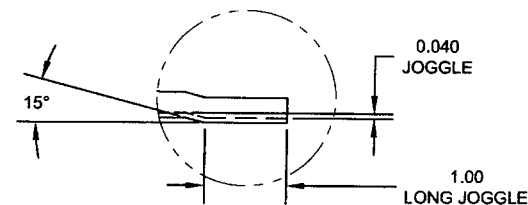
D3508-13F FLAT PATTERN



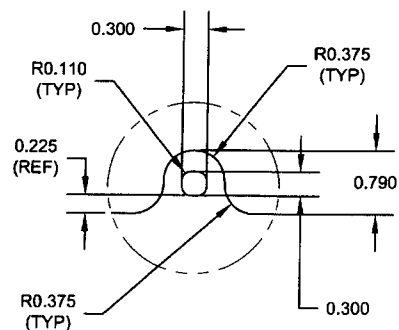
D3508-11 BENDING DETAIL
(MAKE FROM D3508-11F)



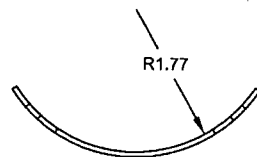
D3508-13 BENDING DETAIL
(MAKE FROM D3508-13F)



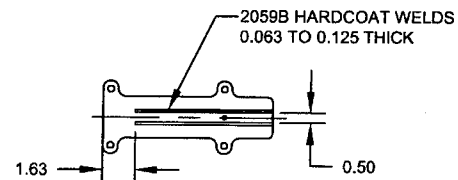
DETAIL C
(SCALE 1:2)



DETAIL A
(SCALE 2:3)



SECTION B-B
(SCALE 2:3)



D3508-13 WELDING DETAIL

DESIGN	PH	DART AEROSPACE USA, INC	
DRAWN	PH	PORT HADLOCK, WA	
CHECKED	B	DRAWING NO.	REV. C
MFG. APPR.	B	D3508	SHEET 2 OF 2
APPROVED	PH	TITLE	SCALE
DE APPR.	PH	WEARPLATE	1:6
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